

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 71977

Thursday, July 14, 2011 3:11:20 PM



Page 2

Item ID: D3531-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket

Start Date: 7/14/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 7/22/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Brake NC Brake NC	NC BRAKE Memo Bend as per Dwg D3531	0.00 0.00		SB 4/6/29		15			
140 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		S 4/6/08		(+15)			
150 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				15			4/6/08/08

Dart Aerospace Ltd

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160 QC3- Inspect Part Finish 0.00



QC Memo 0.00

Quality Control

15x Ø M-11/08/02

170 Identify as per dwg & Stock Location: 65 0.00



Packaging Memo 0.00

Packaging

11/8/2 SL(15)

180 QC21- Final Inspection - Work Order Release 0.00



QC Memo 0.00

Quality Control

ck 11/08/03

11-08-2 (15)

Dart Aerospace Ltd

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Picklist Print

Thursday, July 14, 2011 3:11:28 PM

Page 1

Work Order ID: 71977



Parent Item: D3531-1

Parent Item Name: Bracket

Start Date: 7/14/2011

Required Date: 7/22/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A New Issue 07-09-24 EC verified by DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.040		Purchased	No			100	sf	105.5000	0.3783	2,389,263			



6061-T6 .040 Sheet

Location

MAT021

113004

117653

Loc Qty

105.5

9.5

96

Loc Code

7.2 *AD* 11/07/28

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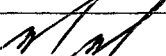
NOTE: Date & initial all entries



DART AEROSPACE LTD		Work Order:	
Description: Bracket		Part Number:	D3531-1
Inspection Dwg: D3531 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.196	+0.005/-0.001	Ø0.196	—		RA26	vern
Ø0.129	+0.005/-0.001	Ø0.129	—		"	
0.33	+/-0.030	.334	—		RA26	vern
2.840	+/-0.010	2.847	—		"	
1.70	+/-0.030	1.703	—		RA26	vern
1.45	+/-0.030	1.460	—		"	"
0.38	+/-0.030	.379	—		"	
0.19	+/-0.030	.202	—		"	
5.88	+/-0.030	5.870	—		"	
12.66	+/-0.030	12.64	—		RA04	Tape
0.600	+/-0.010	.605	—		RA26	vern
1.77	+/-0.030	1.77	—		RA26	vern
1.24	+/-0.030	1.24	—		"	
1.16	+/-0.030	1.16	—		RA04	Tape

Measured by: 	Audited by: 	Prototype Approval:	N/A
Date: 11/07/28	Date: 11.07.28	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.10.15	New Issue	KJ/EC/DD 	

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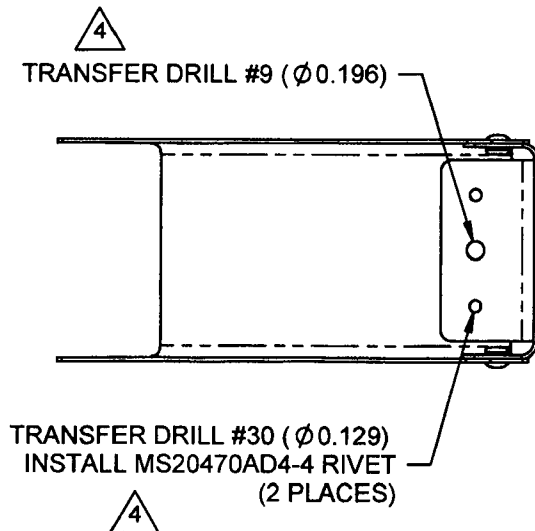
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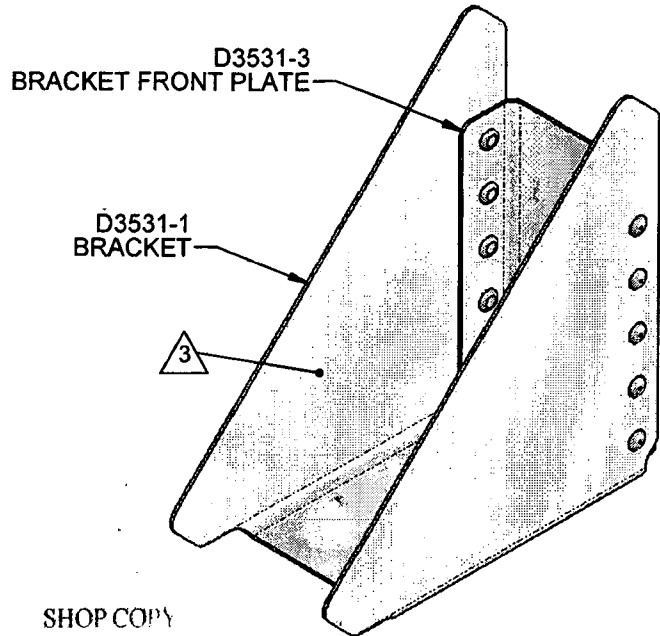
NOTE: Date & initial all entries



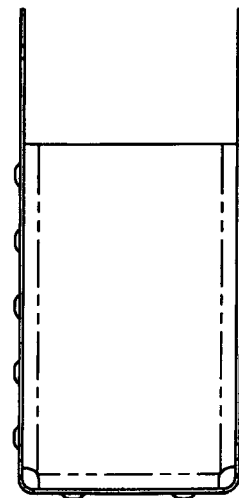
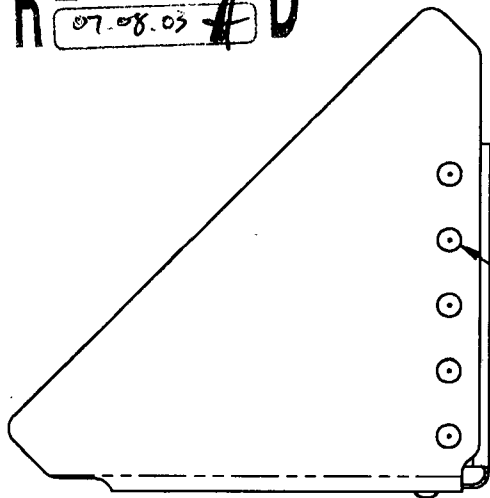
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CHECKED LE	APPROVED [Signature]	DRAWING NO. D3531	REV. A SHEET 1 OF 3
DATE 07.06.19	TITLE BRACKET ASSEMBLY		SCALE 1:2
REV A	DATE 07.06.19	DESCRIPTION NEW ISSUE	



RELEASED
07.08.03



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 71977



D3531-041 BRACKET ASSEMBLY

NOTES:

- 1) FINISH: POWDER COAT ASSEMBLY BLACK
SANDTEX (4.3.5.7) PER DART QSI 005 4.3
ALL PARTS
- 2) ASSEMBLE PER DART QSI 003
- 3) IDENTIFY WITH DART P/N "D3531-041" USING
WHITE MARKER ON INSIDE OF BRACKET
ASSEMBLY, WHERE INDICATED
- 4) TRANSFER DRILL HOLES FROM D3531-1 BRACKET
THROUGH D3531-3 BRACKET FRONT PLATE
BEFORE FINISHING

PARTS LIST

QTY.	P/N	DESCRIPTION
X	D3531-041	BRACKET ASSEMBLY
1	D3531-1	BRACKET
1	D3531-3	BRACKET FRONT PLATE
12	MS20470AD4-4	RIVET

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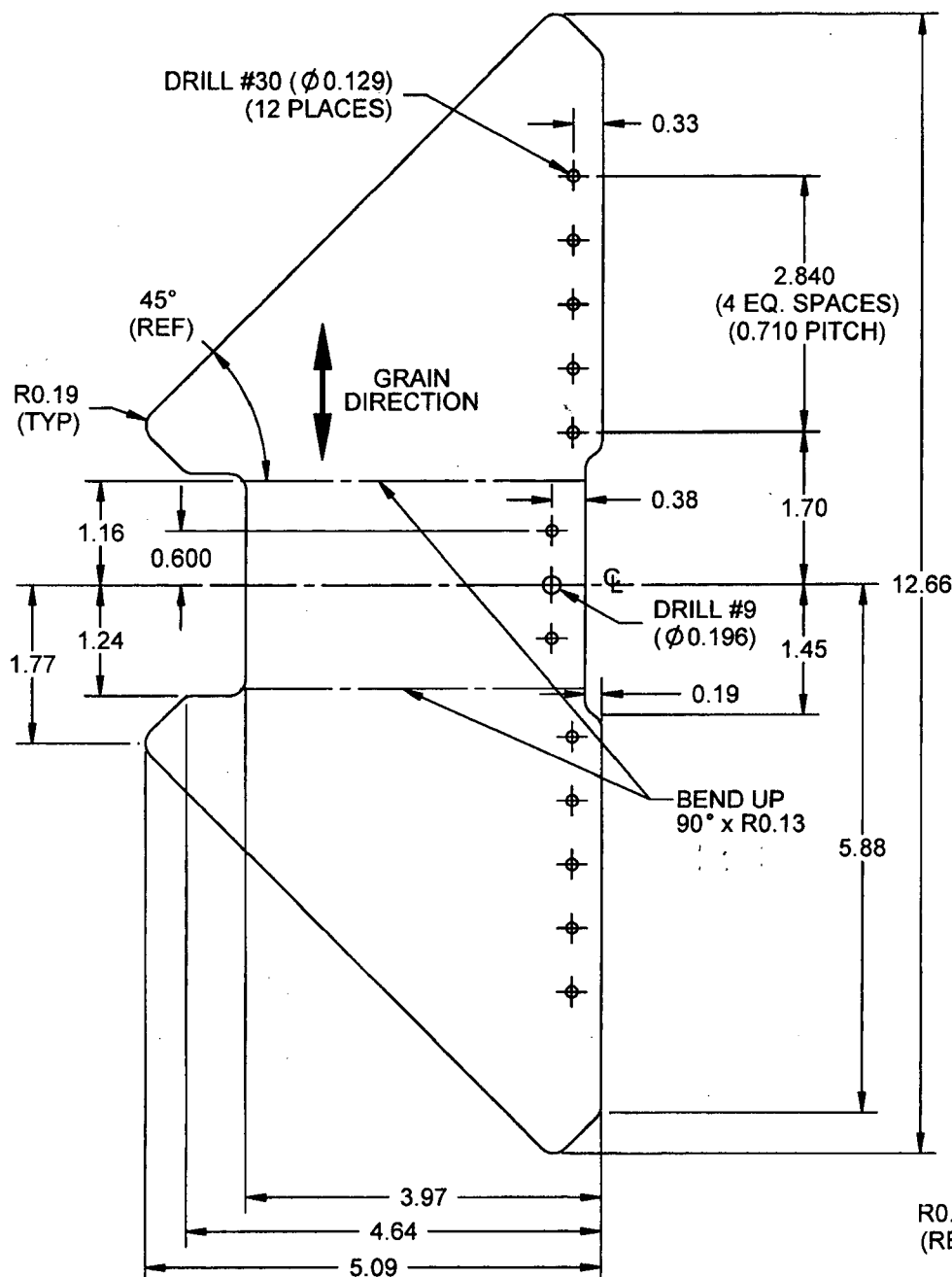
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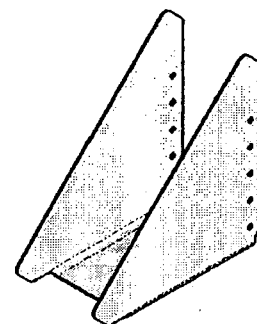
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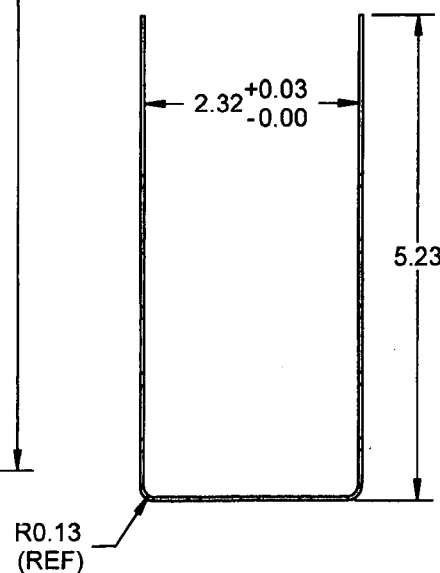
DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED HA	DRAWING NO. D3531	REV. A SHEET 2 OF 3
DATE 07.06.19		TITLE BRACKET ASSEMBLY	SCALE 1:2



D3531-1F FLAT PATTERN



RELEASED
07.08.03



D3531-1 BRACKET

NOTES:

- 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART IS SYMMETRIC ABOUT C

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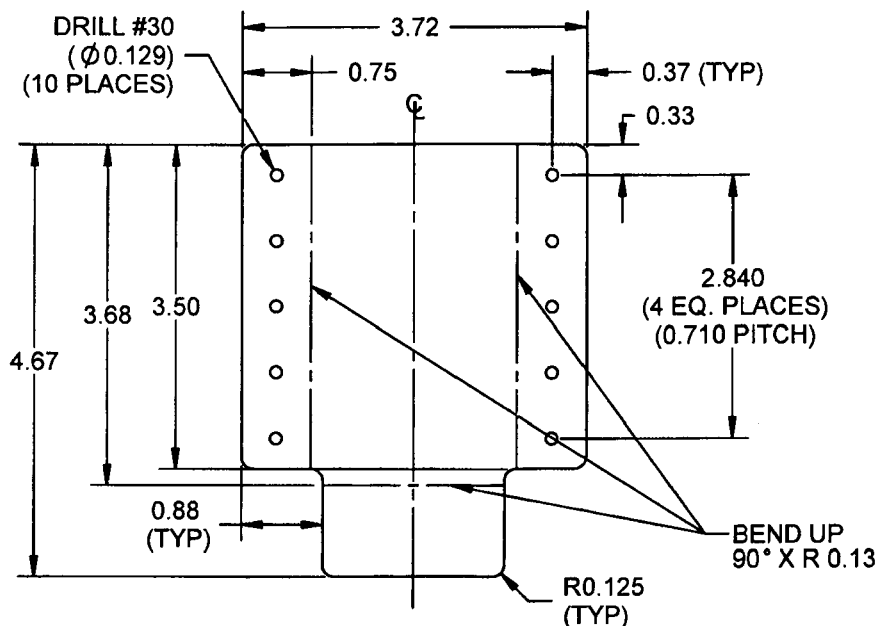
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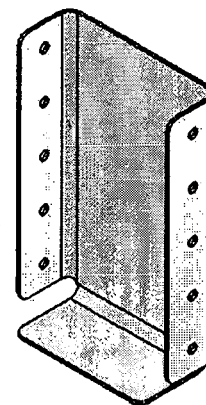


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CHECKED CE	APPROVED [Signature]	DRAWING NO. D3531	REV. A SHEET 3 OF 3
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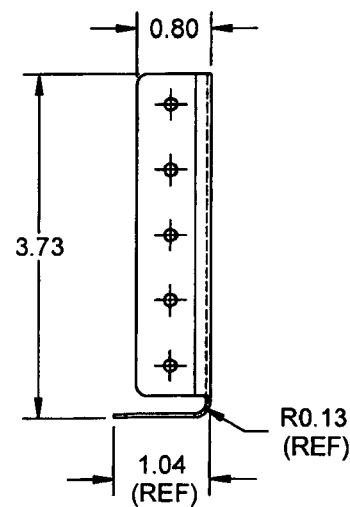
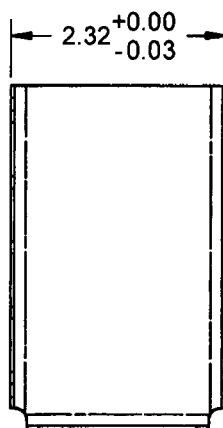


D3531-3F FLAT PATTERN

RELEASED
07.08.03



71977



D3531-3 BRACKET FRONT PLATE

NOTES:

- 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
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- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART IS SYMMETRIC ABOUT ϕ

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